

Work Order ID 74204



Page 1

Tuesday, September 27, 2011 10:26:30 AM

Item ID: D139-799-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Door Hinge

Start Date: 9/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D139-799

E

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D139-799-013
CHG002

003 ECN 11-657 a 11.027 Sulu16

For MJS 11-11-9

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

11/6/10 SP

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

Sulu16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D139-799-013 Location: _____ PPP rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/11/16
SF 10

11/11/17
MF
11/11-16

Picklist Print

Tuesday, September 27, 2011 10:26:27 AM

Page 1

Work Order ID: 74204

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge



Start Date: 9/27/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

S₁₀ D2585



Mounting Channel

Manufactured

No

110

Each

52.0000

1

10

Location

Loc Qty

Loc Code

ST017

52

73297

52

S₁₀ D2586



Door Latch

Manufactured

No

110

Each

15.0000

1

10

Location

Loc Qty

Loc Code

ST204

15

70557

15

S₁₀ D2621



Latch Plate, 350 Spacepod

Manufactured

No

110

Each

62.0000

1

10

Location

Loc Qty

Loc Code

ST019

62

56526

10

73304

52

S₁₀ D3552-12



Door Prop

Manufactured

No

110

Each

27.0000

1

10

Location

Loc Qty

Loc Code

ST272A

27

72101

11

73497

16

B74847

initials (10)

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Picklist Print

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Work Order ID: 74204

Parent Item: D139-799-013

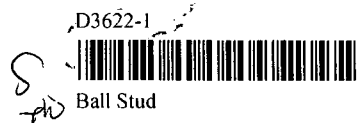
Parent Item Name: Cargo Door Hinge

Start Date: 9/27/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00



Manufactured No

110 Each

25.0000



10

B74486

[Handwritten signature]

Location

Loc Qty

Loc Code

ST070

25

72102

25

Manufactured No

110 Each

51.0000



10

[Handwritten signature]

Location

Loc Qty

Loc Code

ST070

51

53951

31

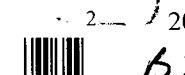
72103

20

Manufactured No

110 Each

0.0000

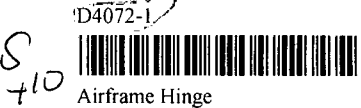


20

B74241

B72104

[Handwritten signature]



Manufactured No

110 Each

31.0000



20

B742205

[Handwritten signature]

Location

Loc Qty

Loc Code

ST119

2

71536

2

ST120

29

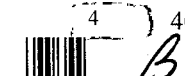
72105

29

Manufactured No

110 Each

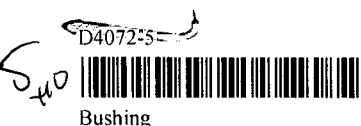
67.0000



40

B74268

[Handwritten signature]



Location

Loc Qty

Loc Code

ST120

67

72106

24

72680

43

3

Tuesday, September 27, 2011 10:26:27 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, September 27, 2011 10:26:27 AM

Work Order ID: 74204

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 9/27/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

D4073-1 Manufactured No

110 Each 0.0000

Door Hinge

D4073-3 Manufactured No

110 Each 15.0000

Door Hinge Backing Plate

Location

Loc Qty

Loc Code

ST120

15

72108

15

D4074-1 Manufactured No

110 Each 26.0000

Bracket

Location

Loc Qty

Loc Code

ST122

26

71542

1

72109

25

D4074-3 Manufactured No

110 Each 62.0000

Channel

Location

Loc Qty

Loc Code

ST120

62

72110

54

72403

8

D4074-5 Manufactured No

110 Each 20.0000

Backing Plate

Location

Loc Qty

Loc Code

ST

16

72111

16

ST122

4

71544

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 74204

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 9/27/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

D4074-7

Manufactured No

110

Each

26.0000

10

Striker Plate

Location

Loc Qty

Loc Code

ST120

5

72112

5

ST122

21

72385

21

MS21042L3

Purchased

No

110

Each

8,411.000

20

200

Nut

Location

Loc Qty

Loc Code

ST300

2411

117441

16

117601

240

117885

155

118451

1000

118927

1000

119017

6000

MS21042L5

Purchased

No

110

Each

1,206.000

1

10

Nut

Location

Loc Qty

Loc Code

ST300

1206

116105

5

116548

262

117441

90

117611

496

118179

300

118910

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 9/27/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

MS27039-1-10

Purchased

No

110

Each

295.0000

8

80



Screw

Location

Loc Qty

Loc Code

ST290

95

117441

95

ST291

200

118612

200

110

Each

118.0000

2

20

MS27039-1-14

Purchased

No



Screw

Location

Loc Qty

Loc Code

MEZZ

118

112312

100

15924

18

110

Each

312.0000

8

80

MS27039-1-16

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST292

312

118384

112

118612

200

110

Each

107.0000

8

80

MS27039-1-17

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST292

107

11540

11

117591

96

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 9/27/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0363J

Purchased

No

110

Each

4,404.000

18

180



Washer

Location

Loc Qty

Loc Code

ST298

4404

117601

274

118077

1130

118612

1000

118968

2000

110

Each

908.0000

1

10

NAS1149D0663J

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST298

908

115996

5

117977

403

118614

500

110

Each

168.0000

4

40

NAS1515H5L

Purchased

No



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

128

111359

5

118378

23

118614

100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-13	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

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Revision: E

Date: 11.08.24

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. E AND ICA-D139-799 REV. 4
REF. FAA STC: SR02138SE

REFERENCE ONLY

PURPOSE:

THE PURPOSE OF THE DART SERVICE INSTRUCTION (DSI) IS TO CHANGE THE P/N OF THE DOOR PROP USED IN D139-799-013 CARGO DOOR FWD OPENING HINGE KIT FROM D3552-13 TO D3552-23 TO PREVENT THE MODIFIED DOOR FROM HITTING THE MAINTENANCE STEP IN THE DOWN POSITION

PARTS LIST CHANGE:

FOR D139-799-013 AT CHG 003 AND SUBSEQUENT, THE PARTS LIST SHOULD BE CHANGED AS FOLLOWS:

5.0 D139-799-013 Cargo Door Hinge Kit (IIN-D139-799 Rev. E)

52.4 D139-799-013 Cargo Door Hinge Kit (ICA-D139-799 Rev. 4)

QTY. -013	PART NUMBER	DESCRIPTION
X	D139-799-013	CARGO DOOR HINGE KIT

IS:

1	D3552-23	DOOR PROP
---	----------	-----------

WAS:

1	D3552-13	DOOR PROP
---	----------	-----------

CUSTOMERS WHO HAVE RECEIVED D139-799-013 AT CHG 002 OR EARLIER CAN OBTAIN THE DSI 9567-011 DOOR PROP KIT FROM DART

QTY -011	PART NUMBER	DESCRIPTION
X	DSI9567-011	DOOR PROP KIT
1	D3552-23	DOOR PROP

PROCEDURE:

REMOVE D3552-13 DOOR PROP AND REPLACE WITH D3552-23 DOOR PROP PER CHAPTER 52 OF ICA-D139-799.

WEIGHT AND BALANCE:

NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE ASSOCIATED WITH THIS CHANGE

A	NEW ISSUE	RF	11.09.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD KENT, WA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9567	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR PROP CHANGE	NTS
DATE	11.09.27	COPYRIGHT © 2011 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	